	er ID 110485 3 11:01:01 AM		*110	)485*						Page 1
Item ID: Revision ID: Item Name:	D3595-063-530  Rubber Cushion		Accept	*N900	040	100	<b>)*</b> s	etup Sta	17	S1* S2*
Start Date: Required Date: Reference:	12/20/13 Start Qty: 2	,		Cust Item l Customer:					··IVI	
Approvals:	Process Plan: MC5 QC:	, -			ate:		R	kun Sta Sto	^ \]	R1* R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3595	Rev A									
*100 *100* Waterjet FLOW CNC Waterj	Dwg Prog		0.00				25	0		Ae 14.01.0
110 <b>*1 1                                  </b>	QC2- Inspect pa	rts off machine FAI/FAIB	0.00				25			<u>Ac</u> 14.01.0
120 *1 20* QC Quality Control	QC8- Inspect pa Me	rts - second check mo	0.00 DAS 27 0.00 969	7			25 Count			

DQA:			Date:										TRAGE
•						WORK ORDER NON-	-CC	ONFO	RMANCE / UP			–	AEROSPACE
QA Closed:			Date:							\	Vork Order u	odate only	
Work Orde	r:					DISPOSITION				/PROCESS			
	-	:				Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	ο.					Scrap	i		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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NCR N	о.					Suspected Unapproved			Large Fab	Composite		Supplier	J ∐
Root	_	<u> </u>			Desci	ription of work order update		nitial	Actio	<b>n</b>	Sign &		
Cause	١	Date	Step	Qty	Desci	or non-conformance	1	ief Eng	i		Date	Verification	QC Inspector
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Doc/Data	$\dashv$						ļ						
Equip/Tooling			·										
Handling/Pre													
Material													
Operator					i						İ		
Offset/Setup													
Process													
Supplier													
Training			:										
Transport													
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		Bending			$\vdash$	Bend	_	-	Program		Outside Din	<b>—</b>	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain			Over/Under		Set-up
		Cracks			$\vdash$	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre	<b>⊢</b>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	$\vdash$	Burrs		-{ `	ion Incomplete/Und	T	Part Lost/M	<u> </u>	Weld
		Cuffs			<u> </u>	Contamination	<u> </u>	-1	tions Incomplete/U	nclear  -	Part Moved		Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	$\vdash$	- 1	gned/off center	-	Positioned \		٦٠٠٠
		Heat Trea				Cut Too Short	$\vdash$	Mislab		Ĺ	Power Loss,	Surge	Other
		Inspection		Tube	<u> </u>	Drawing	-	Misrea					
		Marks/Ch			$\vdash$	Drill Holes	$\vdash$	Off-set					
		Turning S				Finish	$\vdash$	-1	Calibration				
I		Wave/Tw	rist in Lub	e e		Fit/Function		Out of	Sequence				

Work Ore December-20-					*11(	1485*							Page
Item ID: Revision ID: Item Name:	D3595-063			A	Accept	*N900	<b>04</b> 0	100	)*	Setup	Start Stop	1 /	S1* S2*
Start Date: Required Dat Reference:	12/20/13 e: 12/27/13	Start Qty: 25.00 Req'd Qty: 25.00		25* 25*		Cust Item I Customer:	D:						
Approvals:	Process P	lan:	Date:		Tooling: _ SPC (Y/N):		ite:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description		1	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty	*	Reject Number	Insp. Stamp

140

130

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

Memo

0.00

0.00

0.00

\*14**0**\*

\*130\*

Packaging

**Packaging** 

QC

Memo

0.00

**Quality Control** 

Page 2

DAS

26

9-89

DQA:			Date:		*	WORK ODDER NON	cc		DRAARICE / II	IDDATE				7	DART
QA Closed:			Date:			WORK ORDER NON	-C(	JNFUI	RIVIAINCE / U		Wo	ork Order up	date only	٦	AEROSPACE
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raiti	۱O. <sub>.</sub>					Use-as-is	1 1		noforming	Finishing	_		e/Packaging	$\dashv$	Other
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		Centre No	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain				Over/Under			et-up
		Cracks			-	Broken/Damage/Defect	_	Hardwa				Part Incorred	<del> -</del>	1	emperature/Cure
	_	Crimp/Kir	nk/Ripple	:/Wave	<u> </u>	Burrs		1 '	ion Incomplete/L	•		Part Lost/Mi	· -	-	Veld
		Cuffs			$\vdash$	Contamination	$\vdash$	4	tions Incomplete/			Part Moved		^	Vrong Stock Pulled
		Crushing			 	Countersink	$\vdash$	1	gned/off center		_	Positioned V		$\neg_{\sim}$	ut
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	<u> </u>	Inspectio		fube	$\vdash$	Drawing	$\vdash$	Misrea							
	$\vdash$	Marks/Ch			<u> </u>	Drill Holes	-	Off-set					<del></del>		
	<u> </u>	Turning S			<u> </u>	Finish	<b>—</b>	4	Calibration						
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence						

**Picklist Print** 

December-20-13 10:58:47 AM

Work Order ID: 110485

\*110485\*

Parent Item: Parent Item Name:

D3595-063-530

Rubber Cushion

\*D3595-063-530\*

**Start Date:** 12/20/13

Required Date: 12/27/13

Page 1

**Start Qty: 25.00** 

Required Qty: 25.00

**Comments:** 

IPP Rev:A New Issue 07-08-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MNEO80S.125		Purchased	No		100	sf	749.9344	0.0206	1	Λ			
*MNFO80	S 125*							**		$\mathcal{A}$	2 10	4.01.	٥7

**NEOPRENE SHEET 0.125** 

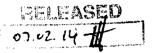
Loc Code Location Loc Oty MAT052 749.9344 115916 131.1044 94539 618.83

 $94539 \rightarrow 1.00$ 

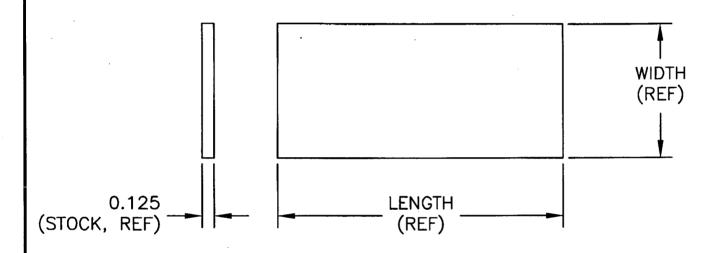
DQA:			Date:										TRACT
			•			WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	·
	•					Rework			Skid-tube Crosstube	e	]	Water Jet	Engineering
Part N	lo.					Scrap		:	Machining Small Fal	$\vdash$	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finishin	g	Rec/Sto	re/Packaging	Other
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	_	Crimp/Kir	nk/Ripple	/Wave	-	Burrs	$\vdash$	1	ion Incomplete/Unqualified	_	Part Lost/Mi		Weld
		Cuffs	ny mppie,	, wave	<b> </b>	Contamination		1 '	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center		Positioned V	L Vrong	
		Heat Trea	ıt			Cut Too Short	$\overline{}$	Mislab			Power Loss/		Other
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		Marks/Ch	·-			Drill Holes		Off-set					
		Turning S				Finish	Г	4	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function	Г	Out of	Sequence				



	DESIG	PH	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAI	
Ī	CHEC	(ED .//	APPROVED /	DRAWING NO.	REV. A
1			1	D3595	SHEET 1 OF 1
Ì	DATE	······		TITLE	SCALE
	07.0	2.07		RUBBER CUSHION	NTS
	Α		07.02.07	NEW ISSUE	



## SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3595-XXX-YYY RUBBER CUSHION WIDTH **LENGTH** 

EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

## **NOTES**

BLACK NEOPRENE SHEET, 0.125 THICK, 1) MATERIAL:

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA:			Date:						_					7
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPA	CE
											•	•		
Work Orde	er:					DISPOSITION			AGAINS	I DE	PARTMENT	PROCESS		
	-	•				Rework			Skid-tube Crosstube	·		Water Jet	Engineering	]
Part N	lo.					Scrap			Machining Small Fat	<u> </u>	Pro	d. Eng. Coor.	Quality	]
						Use-as-is		Thern	noforming Finishing	3 <u> </u>	Rec/Sto	re/Packaging	Other	
NCR N	ю.					Suspected Unapproved	]		Large Fab Composite	<u> </u>	]	Supplier		
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Cause		Date	Step	Qty	Desc	or non-conformance	ı	ief Eng			Date	Verification	QC Inspecto	r
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		Bending			<u> </u>	Bend	L	1	Program	-	Outside Dim	<del>-</del>	Pressure/Forced	
	_	Centre No	ot Concen	itric	<u> </u>	BOM/Route	<u></u>	Grain		$\vdash$	Over/Under	<u> </u>	Set-up	
	-	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa		$\vdash$	Part Incorre	<b> -</b>	Temperature/Cu	e
	_	Crimp/Kir	nk/Ripple,	/Wave	$\vdash$	Burrs	<u> </u>	4 '	ion Incomplete/Unqualified	-	Part Lost/M	ssing	Weld	
	-	Cuffs			<u> </u>	Contamination	-	4	tions Incomplete/Unclear	-	Part Moved	<u>L</u>	Wrong Stock Pull	ea
	$\overline{}$	Crushing	. 4		<u> </u>	Countersink	$\vdash$	4 '	gned/off center	$\vdash$	Positioned V	· · · · · · · · · · · · · · · · · · ·	7 <sub>04</sub> ,	
	$\vdash$	Heat Trea		<b>T.</b> b. :		Cut Too Short		Mislabe			Power Loss/	Surge [	Other	
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	-	Marks/Ch				Drill Holes	$\vdash$	Off-set						
		Turning S	-	10	<u> </u>	Finish Fit/Function	$\vdash$	4	Calibration Sequence					

DART AEROSPACE LTD	Work Order: 8110485
Description: RUBBER CUSHION	Part Number: 03596-063-530
Inspection Dwg: 53595 Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tole	rance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5,30	ャル	. გვი	5,30	•		V	JKm-05
,63	+/-	<b>ে</b> ১১০		_		<u> </u>	
.125	+/-	ن رن	.120	<u> </u>			
		· · · · · · · · · · · · · · · · · · ·	****				
				PAG			

			DAS		
Measured by:		Audited by:	27 } <b>9.8</b> 9	Preliminary Approval:	
Date: / 4, 0/,	07	Date:	14/17	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15